

Date: Monday, 10/22/2007 3:41:49 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	: FITTING
Job Number	: 35285		
Estimate Number	: 10870		
P.O. Number	: N/A	Part Number	: D32163
This Issue	: 10/22/2007 S.O. No. : N/A	Drawing Number	: D3216 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A	Drawing Revision	: A
Previous Run	: 30616	Material	: N/A
Written By		Due Date	: 11/5/2007
Checked & Approved By	: <i>KJ</i> 07.10.23	Qty:	<i>30</i>
Comment	: Est: A 03.10.28 New Issue KJ/RF Est Rev:B Now on Waterjet 06-07-03 JLM	Um:	Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M304S11GA	304/316 .125 Sheet	<i>.4966</i>
		Comment: Qty.: 0.0302 sf(s)/Unit Total : 0.3629 sf(s) 304/316 .125 Sheet (M304S0125)	
		Batch: <i>104934</i>	<i>1B07-10-24</i>
2.0	WATER JET	FLOW WATER JET	
		Comment: FLOW WATER JET 1-Cut as per Dwg D3216	<i>(33)</i>
		Dwg Rev: <i>A</i>	
		Prog Rev: <i>A</i>	
		2-Deburr if necessary	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
			<i>1B07-10-24</i>
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
4.0	QC8	SECOND CHECK	
			<i>counted</i>
		Comment: SECOND CHECK	<i>S 1/10/08 X33</i>
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
		Comment: SMALL & MEDIUM FAB RESOURCE 1	
		Deburr if necessary.	
		Tumble until parts have a polished finish.	<i>SAD 07-10-29</i>
			<i>(33) world</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/01/07
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FITTING

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Part Number: D32163

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Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



Sc 07/11/29 (33) counter

Comment: INSPECT WORK TO CURRENT STEP

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST777

07/11/29 (33)

8.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/11/29

Job Completion



07/10/29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

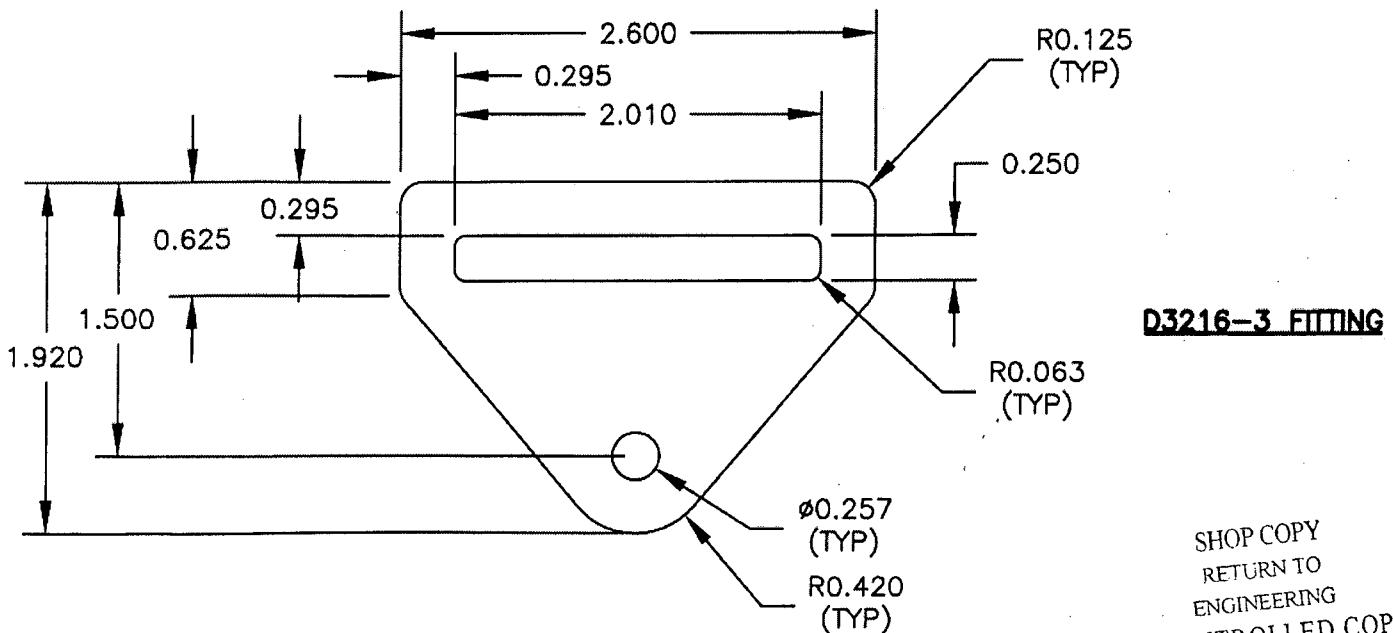
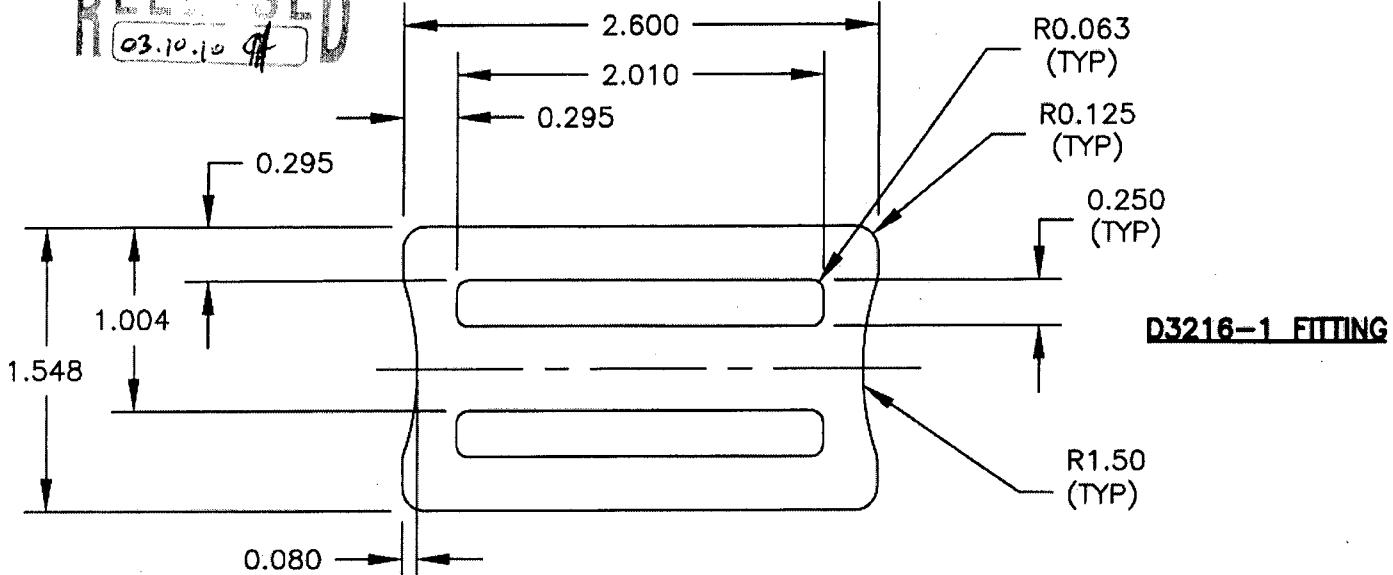
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3216
DATE	03.09.26	REV. A SHEET 1 OF 1
		TITLE FITTING
A	03.09.26	SCALE 1:1
		NEW ISSUE

RELEASED
03.10.10 QF

D3216-1/-3 FITTING

- 1) MATERIAL: AISI 304/316 PLATE, 0.125 THICK (REF DART SPEC. M304S11GA)
- 2) FINISH: MOLECRO POLISH
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 35285

DART AEROSPACE LTD	Work Order:	35285
Description: FITTING	Part Number:	53216-3
Inspection Dwg: 3216-3 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	HB	Audited by:	CR	Prototype Approval:	<input checked="" type="checkbox"/>
Date:	07-10-24	Date:	07/10/24	Date:	<input checked="" type="checkbox"/>

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	